

Work Order ID 97853

97853

Page 1

March-01-13 8:47:11 AM

Item ID: K591-113 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Short Step Instln Kit
 Start Date: 3/01/13 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/19/13 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 13-03-01 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
DSI9525	A								
104	Pick Kit	0.00							
104									
Packaging	Memo	0.00							
Packaging									

Handwritten: 13-03-08 JB

105	QC4- 100% Inspect kits for completeness	0.00							
105									
QC	Memo	0.00							
Quality Control									

Handwritten: 13-4-15

110	Identify as per dwg & Stock Location: _____	0.00							
110									
Packaging	Memo	0.00							
Packaging	***CHG005***								

Handwritten: 13-3-8 10

Work Order ID 97853

97853


Page 2

March-01-13 8:47:11 AM

Item ID: K591-113 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Short Step Instln Kit
 Start Date: 3/01/13 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/19/13 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC21- Final Inspection - Work Order Release	0.00							
120									
QC	Memo	0.00							
Quality Control									

13/4/22 
 213-0419

Picklist Print

March-01-13 8:47:09 AM

Page 1
H

Work Order ID: 97853
Parent Item: K591-113
Parent Item Name: Short Step Instln Kit

Start Date: 3/01/13
Start Qty: 10.00

Required Date: 4/19/13
Required Qty: 10.00

Comments: IPP: C04.11.09ReformatKJ/JLM IPP Rev:D as per revG DD
10.04.20 verified by:EC IPP Rev:E as per ECN10-586 10.06.18 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171 Clamp SP (10)		Manufactured	No			104	Each	12.0000	2	20		97853	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST456		12				10 x B9774 SP			
				94216		12				10 94216			
D2274 Radius Block SP		Manufactured	No			104	Each	432.0000	4	40			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		2							
				86855		2							
				ST008		430							
				65047		12							
				86855		4							
				92418		15							
				95118		153							
				95412		246				95412			
D2182B Rubber Cushion (D2182B035) CUT 2 AT 3.50" SP measure 13-4-15		Manufactured	No			104	f	205.8400	23	5.833			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST412		205.84							
				93429		205.84				93429			
D23623 Support Bracket SP		Manufactured	No			104	Each	3.0000	1	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST478		3							
				89944		3				3x 89944			

7 x B977902 SP
13-4-12

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March-01-13 8:47:10 AM

Page 2

Work Order ID: 97853
Parent Item: K591-113
Parent Item Name: Short Step Instln Kit

Start Date: 3/01/13

Required Date: 4/19/13

Start Qty: 10.00

Required Qty: 10.00

D3595-200-300
RUBBER CUSHION

Manufactured No

104 Each 202.5006

Location	Loc Qty	Loc Code
FG	5	
84209	5	
MAT052	37.3336	
41360	37.3336	
ST415	160.167	
76552	29.167	
84209	14	
95564	117	

Purchased No

104 Each 470.0000

Location	Loc Qty	Loc Code
FG	10	
119086	10	
ST513	460	
123355	443	
123532	17	

Purchased No

104 Each 45.0000

Location	Loc Qty	Loc Code
ST358	45	
122416	45	

Purchased No

104 Each 235.0000

Location	Loc Qty	Loc Code
GA	50	
116419	50	
ST358	85	
122416	85	
ST515	100	
123348	100	

AN3-37A
Bolt

AN4-21A
Bolt

AN4-22A
Bolt

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Page 2

Picklist Print

March-01-13 8:47:10 AM

Work Order ID: 97853

Parent Item: K591-113

Parent Item Name: Short Step Instln Kit

Start Date: 3/01/13

Required Date: 4/19/13

Start Qty: 10.00

Required Qty: 10.00

AN960JD10 Washer Purchased No
 AN960JD416 Washer Purchased No
 MS21042L3 Nut Purchased No

104 Each 0.0000
 104 Each 0.0000
 104 Each 6,727.0000

Handwritten notes and signatures: 124392, 2B, 124198, 2B, 123900, 13-03-08, and various initials.

Location	Loc Qty	Loc Code
FP001	3	
122141	3	
GA	296	
122452	296	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	6160	
123900	2160	
124291	4000	

123900

Picklist Print

March-01-13 8:47:10 AM

Page 4

Work Order ID: 97853

Parent Item: K591-113

Parent Item Name: Short Step Instln Kit

Start Date: 3/01/13

Required Date: 4/19/13

Start Qty: 10.00

Required Qty: 10.00

MS210421L4

Nut

Purchased

No

104

Each

4,878.0000

5

50

JB 13-03-08

31

Location

Loc Qty

Loc Code

FP001

318

122452

306

8182

12

FP-001

12

8182

12

GA

131

121444

131

ST314

75

116548

12

119017

20

123248

27

123355

16

ST506

1342

123900

1342

ST518

3000

124231

3000

123900

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Page 4

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 Heli-Access-Step™ (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:






QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

SHOP CH
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 97853
ML5

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

THE DSI-9525-XXX KITS THAT ARE AVAILABLE FROM DART TO UPGRADE THE D350-591-111A/-113/-115 KITS @ CHG 004 (OR EARLIER), THE D350-591-117A KIT @ CHG 002 (OR EARLIER) AND THE D350-591-119 KIT @ CHG 003 (OR EARLIER) ARE AS FOLLOWS:

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				DSI-9525-011	STEP CUSHION KIT (FOR D350-591-111A)
	X			DSI-9525-013	STEP CUSHION KIT (FOR D350-591-113/-119)
		X		DSI-9525-015	STEP CUSHION KIT (FOR D350-591-115)
			X	DSI-9525-017	STEP CUSHION KIT (FOR D350-591-117A)
2	1	1	1	D3595-200-300	CUSHION
		4		AN4-20A	BOLT
8	4			AN4-21A	BOLT
			4	AN4-22A	BOLT
8	4	4	4	NAS1149D0463J	WASHER (OR AN960JD416)
8	4	4	4	MS21042L4	NUT

INSTRUCTIONS:

TO INSTALL THE D3595-200-300 CUSHION:

1. REMOVE THE STEP PER ICA-D350-591 SECTION 32.2
2. REMOVE THE D2856-400-720 ABRASION STRIP PER ICA-D350-591 SECTION 32.4
3. POSITION THE D3595-200-300 CUSHION AS INDICATED ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.
4. REINSTALL THE STEP PER ICA-D350-591 SECTION 32.1 AS APPLICABLE USING THE NEW HARDWARE PROVIDED AS SHOWN ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.

WEIGHT AND BALANCE:






THERE IS A NEGLIGIBLE WEIGHT INCREASE WITH THIS MODIFICATION.

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

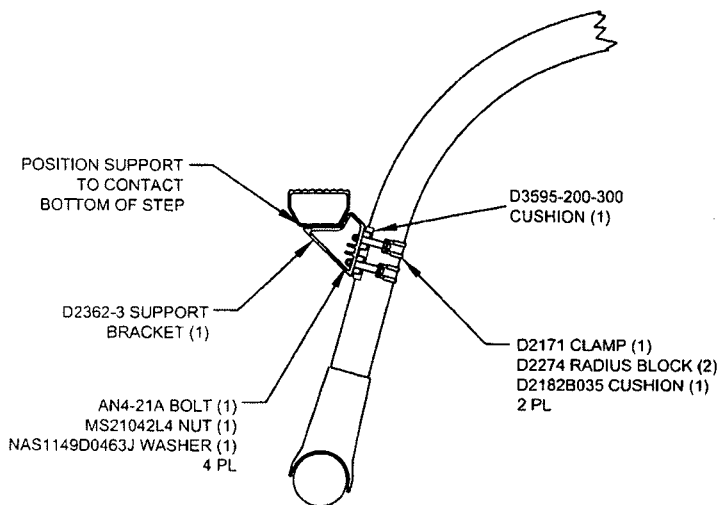
APPROVED

BY: 
D. SHEPHERD (DE # 02)

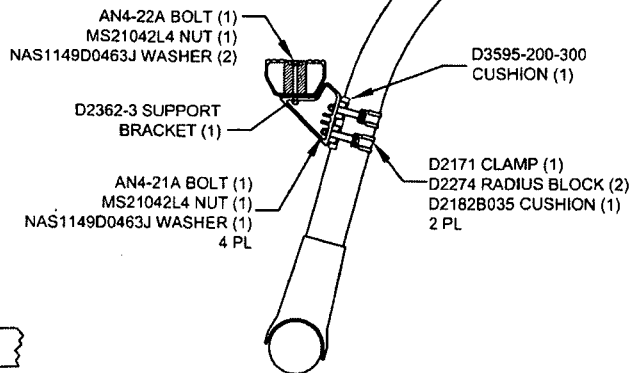
DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 2 OF 4
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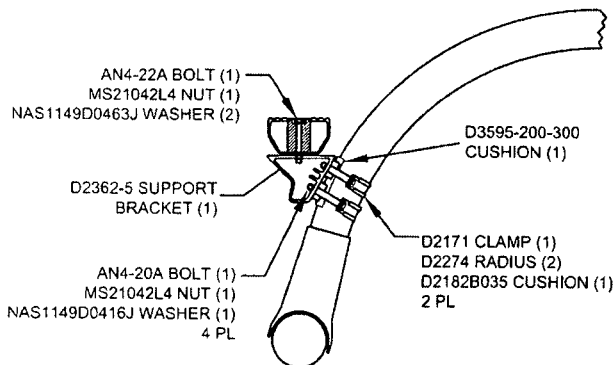
94853



SECTION C-C: CENTER SUPPORT
(D350-591-111A ONLY)
(NOT TO SCALE)



SECTION D-D: AFT ATTACHMENT
(D350-591-111A/-113/-119 ONLY)
(NOT TO SCALE)



SECTION E-E: AFT ATTACHMENT
(D350-591-115 ONLY)
(NOT TO SCALE)

FIGURE 32-9: Crosstube Attachment

REF ICA-D350-591

FIGURE 9: Crosstube Attachment

REF D350-591

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: <i>[Signature]</i>	D. SHEPHERD (DE # 02)
DATE: 10.06.08	
CERT. NO.: SH92-6	
ISSUE NO.: 11	

DESIGN	<i>90</i>	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 3 OF 4
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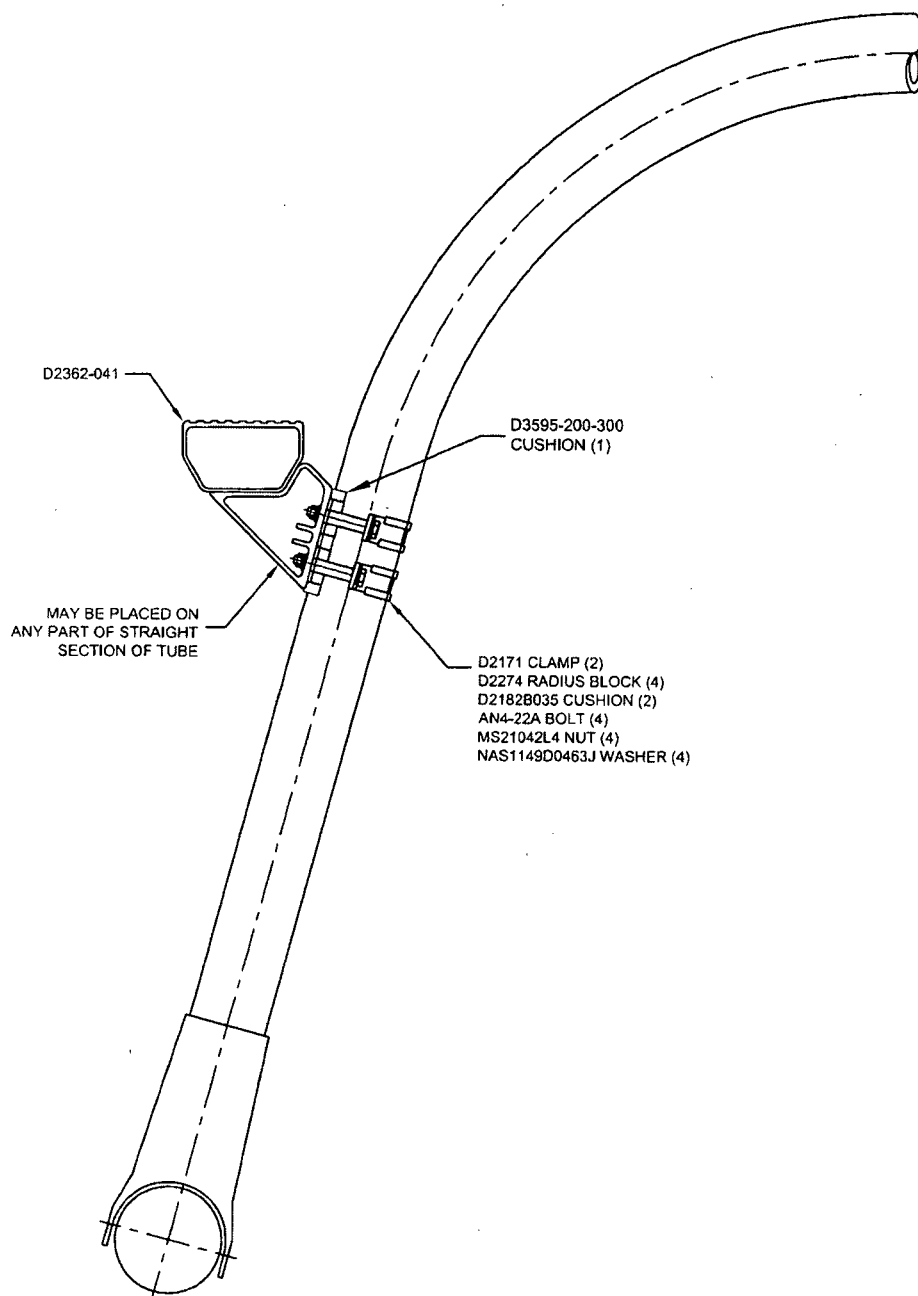


FIGURE 32-10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF ICA-D350-591

FIGURE 10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF D350-591

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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

BY:

D. SHEPHERD (DE # 02)

DATE: 10.06.08

CERT. NO.: SH92-6

ISSUE NO.: 11

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
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MFG. APPR.	N/A	DSI 9525	SHEET 4 OF 4
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97853

13-4-15 s.f

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step™* (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:






FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2			2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
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